

ABSTRACT OF THE DISCLOSURE

The present invention provides an injection molding method which intends to lower a mold clamping force in view
5 of both of a projected area of a molded article and an injection pressure, and contributes to an energy saving and a reduction in a cost of equipment and a manufacturing cost. In a cavity (13) formed in a metal mold (5) for an injection molding, there are arranged a first gate (21) injecting a first
10 molten resin (101) anteceding in one end side (a charging start side) in a longitudinal direction, and a second gate (22) injecting a second molten resin (102) following in another end side (a charging finish side). The second molten resin (102) is newly injected from the second gate (22) before a
15 fluid head portion of the first molten resin (101) injected from the first gate (21) reaches a position of the second gate (22). Further, the first molten resin (101) becomes in an approximately cooled and solidified state by the time when the second molten resin (102) reaches a terminal end in the
20 charging finish side within the cavity (13).